

Date: Thursday, 10/18/2007 7:59:02 AM
 User: Kim Johnston

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BRACKET & CLAMP ASSEMBLY |
| Job Number : 35192 | |
| Estimate Number : 12255 | |
| P.O. Number : <i>N/A</i> | Part Number : D3481043 |
| This Issue : 10/18/2007 S.O. No. : <i>N/A</i> | Drawing Number : D3481 UNDER REVIEW |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 28577 | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 10/24/2007 Qty: <i>5</i> Um: Each |
| Checked & Approved By : <i>[Signature]</i> 07.10.18 | |
| Comment : Est Rev: A New Issue 06-02-03 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------|---------------|
| 1.0 | D34813 | Angle bracket |
|-----|--------|---------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch |
| 1 | D3481-3 | Bracket | <i>B34407</i> |

| | | |
|-----|---|-------|
| 2.0 | QC200566 <i>Q5200525</i> <i>07.10.18</i> | CLAMP |
|-----|---|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

| | | | |
|-----|-------------------------------------|-------------|-----------------|
| Qty | Part Number | Description | Batch |
| 2 | QC200566 <i>Q5200525</i> | Clamp | <i>M1056 03</i> |

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3481

2-Spot Weld as per Dwg D3481

| | | |
|-----|------|-----------------------------------|
| 4.0 | QC11 | VISUAL INSPECTION OF SPOT WELDING |
|-----|------|-----------------------------------|



Comment: VISUAL INSPECTION OF SPOT WELDING

803 07.11.05

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 21/10/06
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 7:59:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET & CLAMP ASSEMBLY

Job Number: 35192

Part Number: D3481043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8B 07/11/5

(5)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

8B 07/11/5

(5)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/11/06

(5)

Job Completion



CL07/11/06

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3481 | REV. A SHEET 1 OF 4 |
| DATE 06.01.23 | | TITLE SHUT-OFF VALVE BRACKET | SCALE 2:3 |
| A | 06.01.23 | NEW ISSUE | |

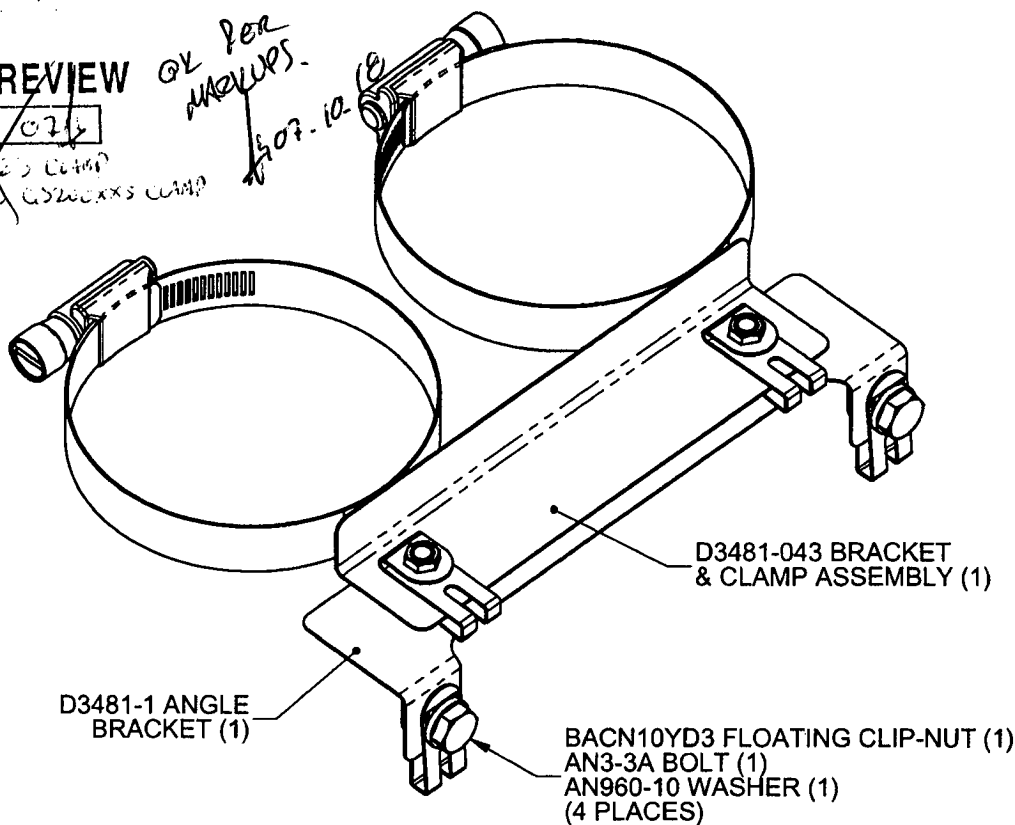
06.04.03
UNDER REVIEW

07.09.02

*Q5200XXS CLAMP
CHANGED TO Q5200XXS CLAMP*

*Q2 Per
MEWUS.*

07.10.12



D3481-041 SHUT-OFF VALVE BRACKET

1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|--------------------------|
| X | D3481-041 | SHUT-OFF VALVE BRACKET |
| 1 | D3481-043 | BRACKET & CLAMP ASSEMBLY |
| 1 | D3481-1 | ANGLE BRACKET |
| 4 | AN3-3A | BOLT |
| 4 | AN960-10 | WASHER |
| 4 | BACN10YD3 | FLOATING CLIP-NUT |

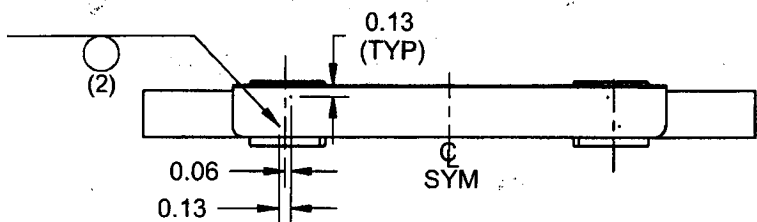
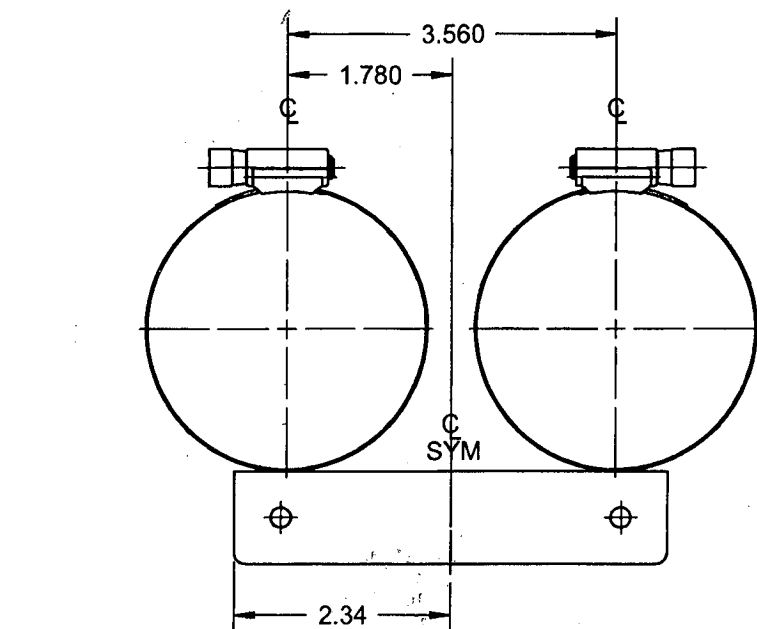
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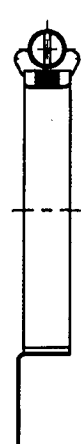
DART

| | | | |
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| DATE 06.01.23 | | TITLE SHUT-OFF VALVE BRACKET | SCALE 1:2 |



Q5200525
Q5200563
AERO-SEAL CLAMP
(2 PLACES)

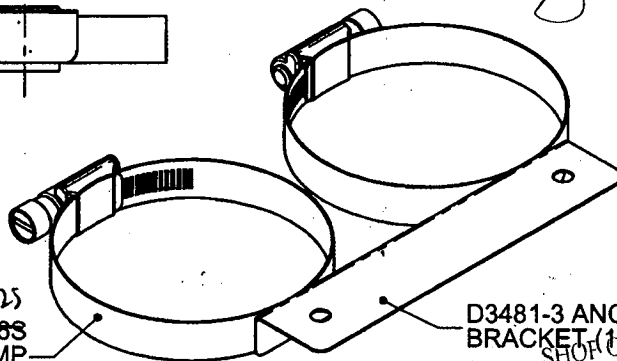
[Signature] 06.04.03



[Handwritten notes]
02 per max 0.15

UNDER REVIEW

07.07.07
Q5200563 CLAMP
CHANGED TO Q5200563 CLAMP



D3481-3 ANGLE
BRACKET (1)
SHORT COPY

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WORK ORDER
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D3481-043 BRACKET & CLAMP ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

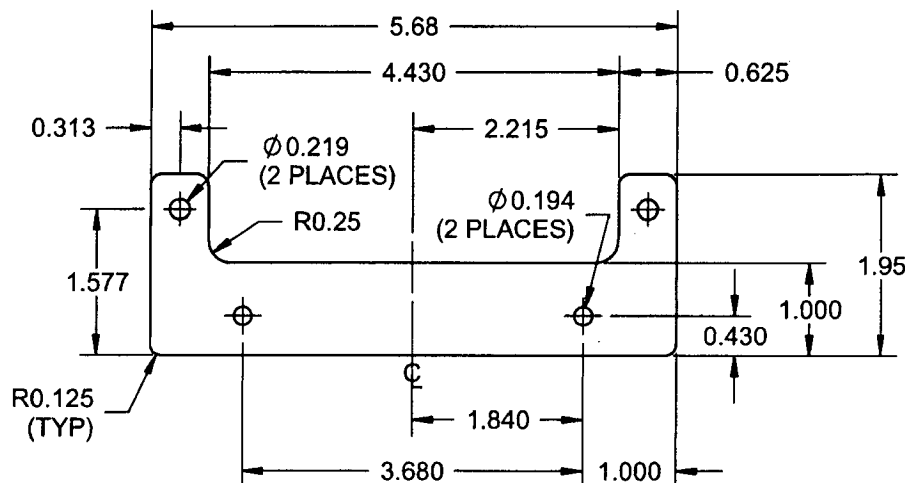
| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|--------------------------|
| X | D3481-043 | BRACKET & CLAMP ASSEMBLY |
| 1 | D3481-3 | ANGLE BRACKET |
| 2 | Q5200525 | |
| | Q5200563 | AERO-SEAL CLAMP |

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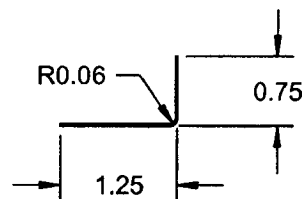
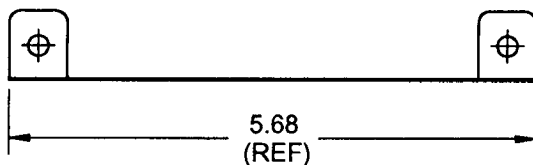
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| DATE 06.01.23 | | TITLE SHUT-OFF VALVE BRACKET | SCALE 1:2 |



D3481-1F FLAT PATTERN

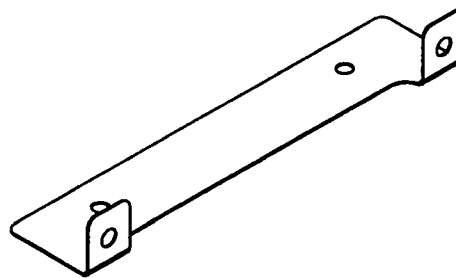


D3481-1 ANGLE BRACKET

[Handwritten signature] 06.04.03

UNDER REVIEW

07.09.07
Q5200705 CAMP
CHANGED TO Q5200XXS CAMP



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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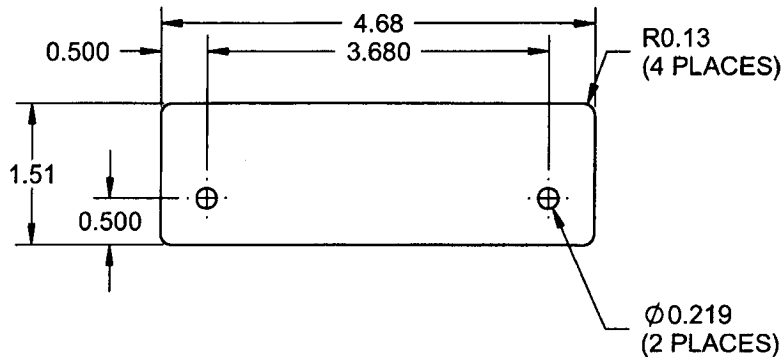
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3481 | REV. A SHEET 4 OF 4 |
| DATE 06.01.23 | | TITLE SHUT-OFF VALVE BRACKET | SCALE 1:2 |

UNDER REVIEW

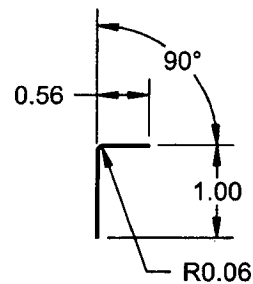
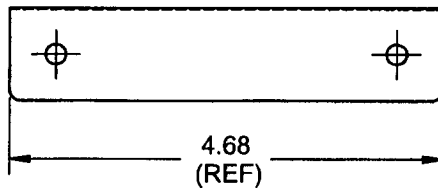
07.09.02

Q5200703 COMP
CHANGED TO Q5200703 COMP

06.04.03



D3481-3F FLAT PATTERN



D3481-3 ANGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 39

EMPLOYEE: Emile Bowler

PART NUMBER: D 3481-043

JOB NUMBER: 35792

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

| | PASS | FAIL |
|----------------|---|------------------------------|
| VISUAL: | [<input checked="" type="checkbox"/>] | [<input type="checkbox"/>] |
| PENETRATION: | [<input checked="" type="checkbox"/>] | [<input type="checkbox"/>] |
| PULL STRENGTH: | [<input checked="" type="checkbox"/>] | [<input type="checkbox"/>] |

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/11/05
QUALIFIER: SB